

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017450**Date Inspected:** 14-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance Inspector (QAI) Bert Madison was present at Yerba Buena Island in California between the times noted above for observations relative to the work being performed by American Bridge/Fluor Enterprises (AB/F) personnel at the locations noted below.

- 1). OBG Field Splice 6W/7W Weld ID: C1 & C2, Face A - (FCAW-G)
- 2). OBG Field Splice 6W/7W Weld ID: A3, Face A – (QC UT of R-1 Repairs)

- 1). OBG Field Splice 6W/7W Weld ID: C1 & C2, Face A - (FCAW-G)

The QAI periodically observed AB/F approved welder Song Tao Huang (ID 3794) assisted by AB/F approved welder Jin Quang Huang (ID 9340) performing semi automatic welding per the Flux Cored Arc Welding (FCAW-G) process in the 3G (vertical) position of root and fill passes on weld ID: C1 & C2. The QAI observed QC Inspector John Pagliero was present to monitor the progress and verify that the welding parameters were within the limits established by the approved Welding Procedure Specification (WPS) identified as ABF-WPS-D1. 5-3042B-1. The QAI observed that the work at this location was in process for the duration of the shift and appeared to be in general compliance with contract documents. See photos below

- 2). OBG Field Splice 6W/7W Weld ID: A3, Face A – (QC UT of R-1 Repairs)

The QAI periodically observed SE QC Inspector Jesse Cayabyab performing Ultrasonic Testing (UT) from the A Face of OBG Field Splice 6W/7W Weld ID: A3. Mr. Cayabyab utilized the UT Procedure identified as SE-UT-D1. 5-CT-100 Rev.4 during the examination of the CJP. The QC technician performed the shear wave testing utilizing a .63 x .75 rectangular transducer to test for weld soundness. The UT examination was completed during this shift. At the conclusion of the QC testing, the QAI observed that the QC technician noted two (2) rejectable flaws which

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were marked on the A face of the splice weld. The R-1 reject indications were located as follows: Y = 3865mm, length = 10mm and depth was marked as 12mm and Y = 4045mm, length = 10mm and the depth was marked as 11mm.

The QA Inspector performed a job site walk through and noted the current welding and NDE status of the OBG at the job site. After the information was gathered in the field, the QA Inspector updated the Caltrans QA Production/NDT tracking log and transferred the information to the chart in the Caltrans SAS office on the job site.



Summary of Conversations:

Conversations on this date with Quality Control Inspectors were general in nature and pertained to locations of welding and QC activities.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammed Fatemi (916) 813 3677, who represents the Office of Structural Materials for your project.

Inspected By: Madison,Bert

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer